

Work Order ID 70980

Monday, June 20, 2011 2:47:48 PM



Page 1

Item ID: D3405-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Assembly

Start Date: 6/20/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: MDate: 11-06-20 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3405

Dwg Rev: BProg Rev: B

2-Deburr if necessary

B11-6-21(12)

304-178

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

B11-6-21

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

8/10/21(X12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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QC:

Date:

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Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(12)			
Brake NC	Memo 1-Deburr 2-Form using DT8204 as per Dwg D3405 3- use DT9681 to check if correct forming	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00				(+12)			
Quality Control	Memo	0.00							
150  Large Fab	Large Fab	0.00							
Large Fab	Memo Weld as per Dwg D3405 use DT8484 Identify as D3405-041	0.00							

SA 11/07/14

S 11/07/14

EL 11-8-25 (17)

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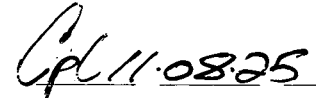



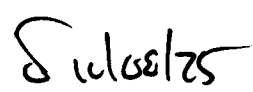


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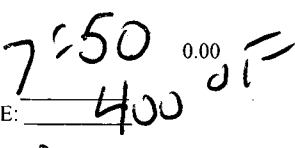

Item ID: D3405-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Lug Assembly
Start Date: 6/20/2011 Start Qty: 10.00  Cust Item ID:
Required Date: 6/23/2011 Req'd Qty: 10.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							
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170  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
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180  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00							
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M 117745

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Page 4

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Cust Item ID:

Required Date: 6/23/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

200

Identify as per dwg & Stock Location: ST 478 0.00

0.00



Packaging

Memo

0.00

Packaging

17x SP 11-08-29.

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/29

11-08-29

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Picklist Print

Monday, June 20, 2011 2:47:56 PM

Page 1

Work Order ID: 70980

Parent Item: D3405-041

Parent Item Name: Lug Assembly

Start Date: 6/20/2011

Required Date: 6/23/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 05.09.01 ☐ New issue ☐ KJ/JLM ☐
IPP B 09.01.28 rev.B drawing EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3404-1		Manufactured	No			100	Each	35.0000	1	10			
													
GHW Lug													

72326 x12

Location	Loc Qty	Loc Code
WA	32	
69883	32	
WA030	3	
67127	3	

M304S11GA		Purchased	No			150	sf	113.0000	0.154	1.621053			
													
304/316 0.125 Sheet													

Location	Loc Qty	Loc Code
MAT020	113	
117494	113	

117494

D3405-7 X 5 EZ 11-8-24
B72072

(12)

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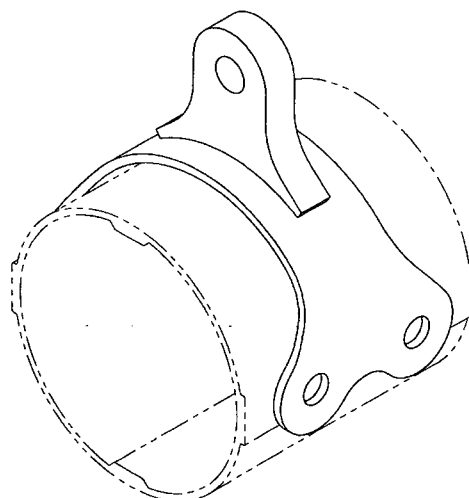
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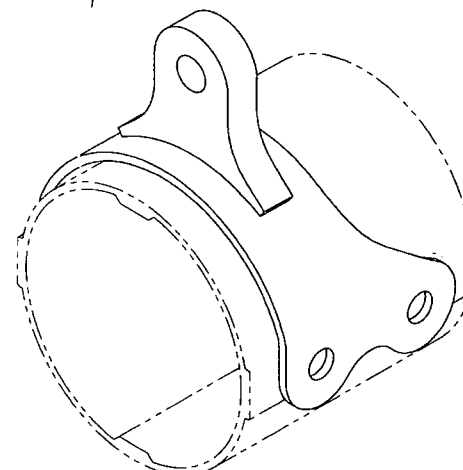
ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70980
PH-06-20



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

RELEASED
08/12/18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
DATE	08.09.19	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

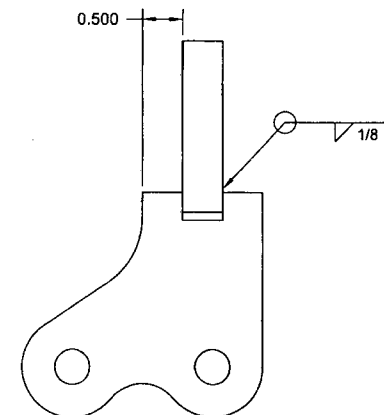
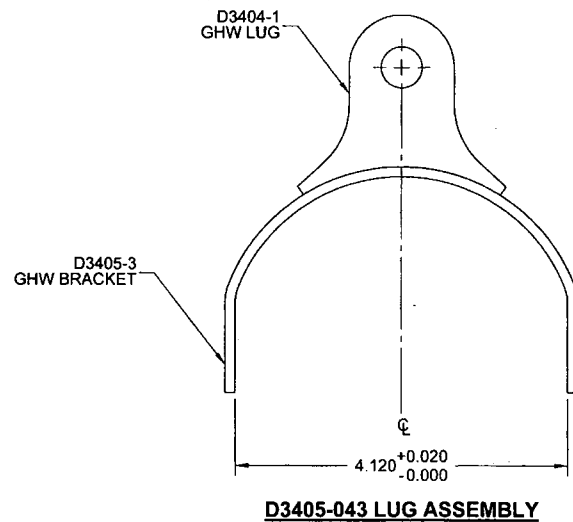
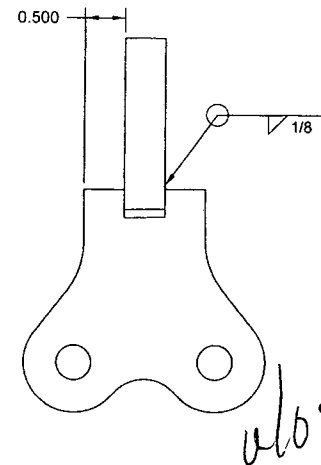
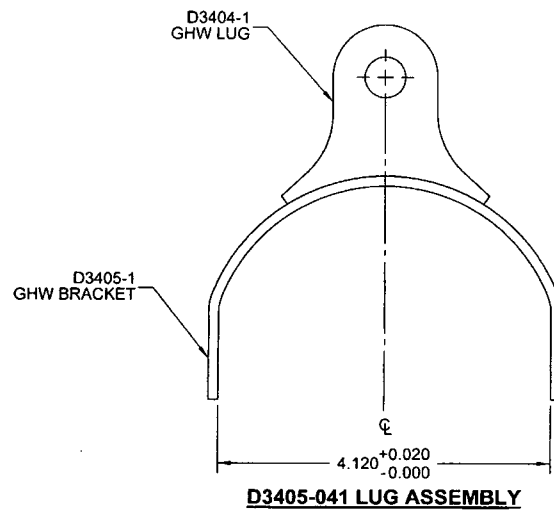
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RELEASED
6/12/18 MIP

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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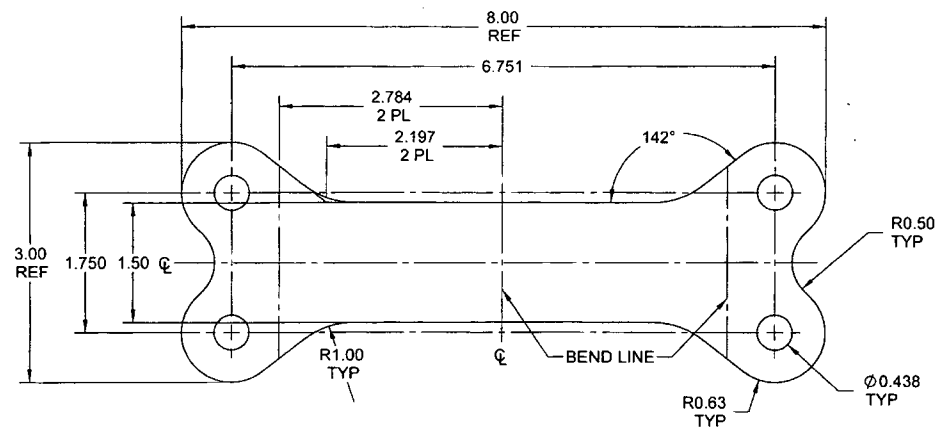
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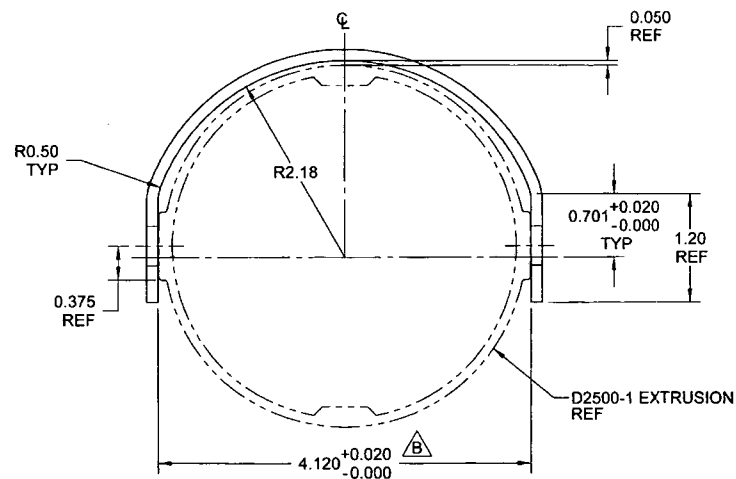
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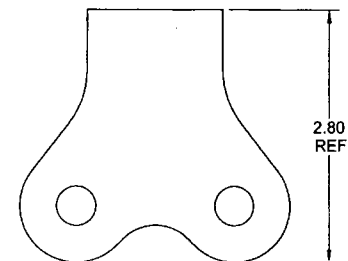
NOTE: Date & initial all entries



D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



SIDE VIEW FOR REF ONLY

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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RELEASED
01/08/12/18

W/ 70986

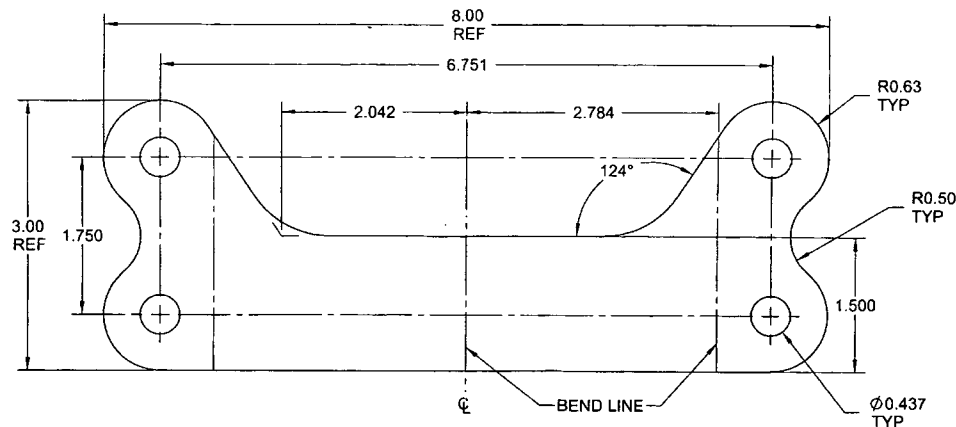
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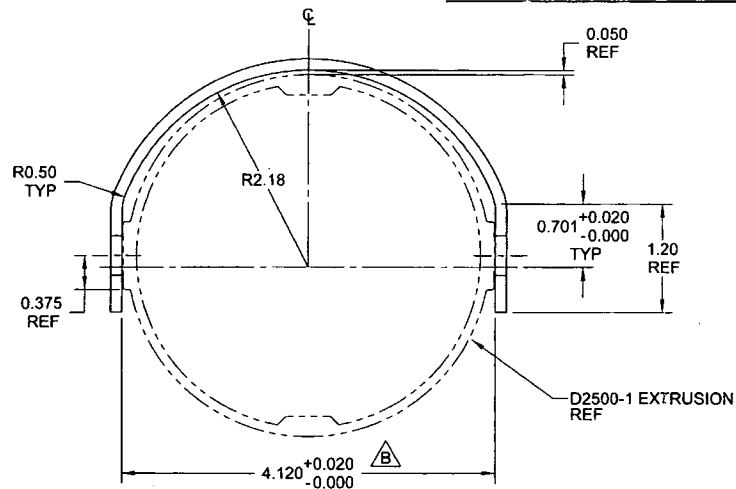
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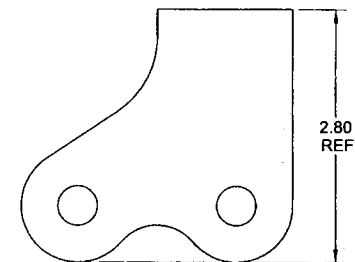
NOTE: Date & initial all entries



D3405-3F GHW BRACKET FLAT PATTERN



D3405-3 GHW BRACKET
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

w/670980

RELEASED
06/12/14

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
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REF. DART SPEC. M304S11GA
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- 7) WEIGHT: N/A

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